

Date: Wednesday, 9/13/2006 4:34:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 - Dart Helicopters Services
 Job Number : 28540
 Estimate Number : 12182
 P.O. Number : N/A
 This Issue : 9/13/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 26113
 Written By : 10 06 09 14
 Checked & Approved By : 10 06 09 14
 Comment : est rev A 06-02-06 new issue EC

Drawing Name : SHUT-OFF VALVE SHAFT
 Part Number : D34693
 Drawing Number : D3469 REV.A1
 Project Number : N/A
 Drawing Revision : A1
 Material : N/A
 Due Date : 10/5/2006
 Qty: 3 Um: Each

Split PART 1

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2857 sf(s)/Unit Total: 1.1428 sf(s)

304/316 0.018 SHEET

(M304S26GA)

Batch: 1102376

ml 06 10 14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3469

Dwg Rev: A1

Prog Rev: A1

ml 06 10 14

3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 10 14

3

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Job 10-18 3

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

ml 06/10/20

3

2-form outer flange as per dwg D3469 using DT8851

3-form oval flanges per dwg D3469 using DT8850

SB 06/10/24

3

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Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Number: 28540

Part Number: D34693

Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



200-10-24 (3)



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *240*

200-10-25 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

200-10-25

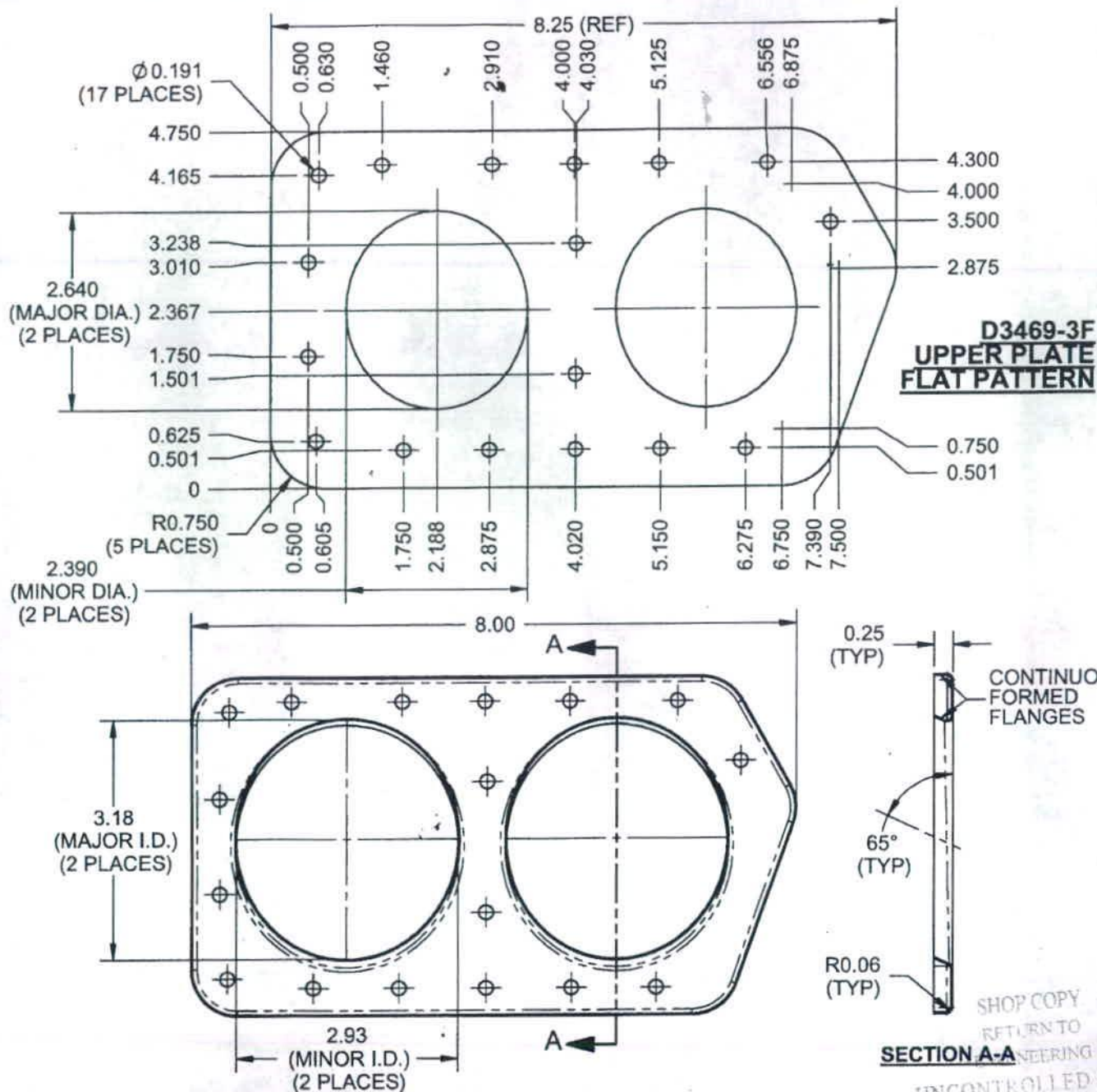
Job Completion



200-10-25

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 4 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2	

**D3469-3 UPPER PLATE BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
SECTION A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **28540**

RELEASED

[Signature] 06.07.03

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